


Work Order ID 75876

75876

Page 1

Thursday, November 17, 2011 4:00:50 PM

Item ID: K10112 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Skidtube 206
 Start Date: 11/1/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/9/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan:  Date: 11/17 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9583	A								
K10112	B								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP K10112 CHG003 FOR D206-642-111 CHG006 <u>CHG002</u> FOR D206-642-113 CHG002 <u>CHG002</u>								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

12/01/03
CK for MLT 11/12/23
11/12/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75876***75876***

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Thursday, November 17, 2011 4:00:50 PM

Item ID: K10112

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/9/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

5/2/01/03

X4

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K10112
PPP D206-642-111
PPP D206-642-113
Location: _____
PPP rev: _____

75722

75719

75720

75724

12/1/03

PC (4)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

CK 12/01/04

M.L.J 12/01/03

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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75876

K10112

Required Date: 12/9/2011

Required Qty: 4.00

Comments: IPP: E00.06.14Changed GHW part # (mpp 2063)ECIPP REV:F
11.09.23 PER REV.B DD VERF:EC IPP REV:G 11.11.14
AS PER DSI9583 DD VERF:EC

119042

Let 4/01/3 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 75876

75876

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-6A Purchased No

110 Each 5,062.000 12 48

**

AN4-6A

Bolt

Location

Loc Qty

Loc Code

ST356

62

119127

62

ST516

5000

119017

5000

119017

AN4C5A Purchased No

110 Each 489.0000 1 4

**

AN4C5A

BOLT

Location

Loc Qty

Loc Code

FP-B

49

112243

49

ST355

440

112243

340

119017

100

112243

AN6-44A Purchased No

110 Each 511.0000 2 8

**

AN6-44A

Bolt

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

504

119036

504

119036

D206-651-041 (H7001) Manufactured No

110 Each 1.0000 1 4

**

D206-651-041

206A/B GHW

Location

Loc Qty

Loc Code

FG125

1

74002

1

76080

12/01/3 (4)

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Thursday, November 17, 2011 4:00:54 PM

Work Order ID: 75876

75876

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2652

Manufactured No

110

Each

743.0000

16

64

**

76132 160 *CU*

Sy ***D2652***

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

699

73835

579

73836

120

73834 48 *CU*

D2661-2

Manufactured No

110

Each

11.0000

2

8

**

76765 20 *CU*

Sy ***D2661-2***

Saddle, RH Fwd Aft Out 206

Location

Loc Qty

Loc Code

MEZZ

6

10015

1

10016

1

10476

3

9913

1

ST435

5

74474

3

76517

2

76802 60 *CU*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75876

75876

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2662-2

Manufactured No

110

Each

29.0000

2

8

**

D2662-2

Saddle, RH In 206

76798 6P

76798 26

Location

Loc Qty

Loc Code

Mezz

2

11028

4

9042

3

9043

2

ST429

5

73852

2

76519

3

ST435

15

73853

15

D2712

Manufactured No

110

Each

2,551.000

10

40

**

D2712

Set Screw

76065

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

2501

71160

1

73837

500

76065

2000

D2884

Manufactured No

110

Each

100.0000

2

8

**

D2884

Saddle Spacer

76751/CH/423(4)

Location

Loc Qty

Loc Code

FG

10

29453

10

ST025

90

73823

90

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 75876

75876

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2885

Manufactured No

110

Each

126.0000

2

8

**

76752

D2885

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29199

10

ST025

116

73824

116

Manufactured No

110

Each

94.0000

1

4

**

73822

D3413-1

D3413-1

Ring

Location

Loc Qty

Loc Code

ST368

2

73821

2

ST420

2

66387

1

70773

1

ST469

88

73822

88

ST473

2

71041

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 75876

75876

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

110

Each

8,781.000

8

32

**

MS21042I 3

Nut

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2526

119075

2526

119075

MS21042L4

Purchased

No

110

Each

11,520.00

12

48

**

MS21042I 4

Nut

Location

Loc Qty

Loc Code

ST300

558

117441

51

117601

374

118451

133

ST516

5962

119017

5962

ST518

5000

119075

5000

119017

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 75876

75876

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L6

Purchased

No

110

Each

1,484.000

2

8

**

MS21042L6

Nut

Location

Loc Qty

Loc Code

ST300

484

117677

25

118384

5

118927

48

118968

406

ST518

1000

119075

1000

118968

NAS1149C0463R

Purchased

No

110

Each

1,379.000

1

4

**

NAS1149C0463R

Washer

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1378

117735

378

119097

1000

117735

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Thursday, November 17, 2011 4:00:54 PM

Work Order ID: 75876

75876

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

4,466.000

8

32

NAS1149D0363.I

Washer

LocationLoc QtyLoc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1450

117601

148

118077

1

118612

55

118968

1246

110

Each

12,710.00

24

96

NAS1149D0463J

Purchased

No

NAS1149D0463.I

Washer

LocationLoc QtyLoc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12386

119075

10000

119097

2386

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Thursday, November 17, 2011 4:00:54 PM

Work Order ID: 75876

75876

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

5,153.000

8

.32

NAS1149D0563.I

Washer

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3153

118206

2153

118614

1000

118206

NAS1149D0663J

Purchased

No

110

Each

2,598.000

4

16

NAS1149D0663.I

Washer

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

119075

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-112
BELL 206 A/B	D206-642-114

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10112	D206-642-112	D206-642-114
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-2	2	2	2
5	D2662-2	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-114	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	K10112	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE KIT	NTS
DATE	11.11.10	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	